

Work Order ID 53972

November 24, 2009 2:44:24 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 11/25/09 Start Qty: 3.00

Required Date: 11/30/09 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference: *REWORK ONLY*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

140

0.00



Skidtubes

Skidtubes

Memo

0.00

- REMOVE SADDLES AND PLUGS
- BAG & TAG PARTS TO RETURN TO PROPER SKIDTUBE
- DRILL OUT CROSSBOLT SPACERS WITH 1/2" UNIBIT
- CHAMFER CROSSBOLT SPACER HOLES AT 0.500" X 45 DEGREE
BEFORE WELDING
- REMOVE POWDERCOAT & CLEAN AREA TO BE WELDED
- INSERT CROSSBOLT SPACER D2579. WELD ONE SIDE AND MAKE
SURE TO BACK DRILL AFTER WELDING.
REPEAT PROCESS FOR OTHER SIDE. PER QSI004
- GRIND WELDS FLUSH
- COUNTERBORE CROSSBOLT SPACERS AT 0.437" X 1.00"

AR-H112507
x-bolt spacer - B31525
(66)

DPH / BE

9-12-2

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

3

105-1202

DART		TEL: 1-813-632-3336 FAX: 1-813-632-4447	
P/N	D205-634-011	CHG	CHG005
DESC	Skidtube	STG	SH9308
LOT	B37497	STO	SR00563NY
MODEL	Bell 205/210/212/214/412	STC	
US PATENT 5,870,885 CANADA FOREIGN PATENT 2,155,710		MADE IN CANADA	

Work Order ID 53972

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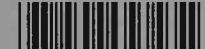
Page 2

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 11/25/09 Start Qty: 3.00

Required Date: 11/30/09 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

3

20.12.02

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

-PRESSURE WASH PER QSI005
-TOUCH UP ALODINE

BR 09-12-3

(3)

175

0.00



SprayPaint

Memo

0.00

Spray Painting

MASK WHERE NECESSARY
SPRAY PAINT WHITE PER QSI005

=>

ml 09 12 03 (X3)

Work Order ID 53972

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Page 3

Item ID: D205-634-041
Revision ID: D
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 11/25/09 Start Qty: 3.00
Required Date: 11/30/09 Req'd Qty: 3.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC
Quality Control

QC3- Inspect Part Finish
QC14
Memo

0.00
0.00

3

09/12/04

200

HandFinish
Hand Finishing

Memo
-Wing Walk as per Dwg D2580 and QS1 005 4.4
Batch: M12623

0.00
0.00

MND 09/12/04

X3

210

QC
Quality Control

QC5- Inspect part completeness to step on W/O
Memo

0.00
0.00

SD 09/12/04

(X3)

Work Order ID 53972

November 24, 2009 2:44:25 PM



Page 4

Item ID: D205-634-041

Accept



Setup Start



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Stop



Item Name: Replacement Skidtube

Start Date: 11/25/09 Start Qty: 3.00



Cust Item ID:

Required Date: 11/30/09 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041
RETURN TO EAGLE (VIII)

no work

09/12/09

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Lawork - 09/12/10 HJ

09/12/10

REPAIR SCHEME FOR V.I.H. SKIDTUBE

- 1- REMOVE SADDLES AND PLUGS. MAKE SURE TO BAG AND TAG ALL REMOVED HARDWARE WITH PROPER SKIDTUBE.
- 2- DRILL OUT CROSSBOLT SPACERS WITH A ½" UNIBITE
- 3- CHAMFER CROSSBOLT SPACER HOLES AT 0.500" X 45 DEGREE BEFORE WELDING
- 4- REMOVE POWDERCOAT AND CLEAN AREA TO BE WELDED
- 5- INSERT CROSSBOLT SPACER D2579. WELD ONE SIDE AND MAKE SURE TO BACK DRILL AFTER WELDING. REPEAT PROCESS FOR OTHER SIDE. WELD AS PER QSI004.
- 6- GRIND WELDS FLUSH
- 7- COUNTERBORE CROSSBOLT SPACER AT 0.437" X 1.00"
- 8- CLEAN SKIDTUBE BEFORE PAINTING
- 9- MASK WING WALK
- 10- SPRAY PAINT SKIDTUBE WHITE AS PER QSI005
- 11- WING WALK SKIDTUBE IF NECESSARY AS PER QSI005

53972

Custom who

indicate P/N's
& B/N's for traceability

Kim

L Lacelle

From: Kelly Labas [klabas@eaglecopters.com]
Sent: November 11, 2009 10:21 AM
To: 'L Lacelle'; 'Bill Beckett'; 'David Duval'
Cc: ssheldon@dartaero.com; mpetsche@dartaero.com; 'Dan Stow'; 'Craig Swayne'
Subject: RE: Repair to VIH Skidtube
Categories: Holiday Cards

Handwritten notes:
2 014 89
18,99 / 35 468⁰⁰
15 85 / 24 45 120⁰⁰

Yikes! How much to paint if we do not disassemble just slam them thru the both to make them look somewhat respectable, they are used tubes.

What's Eagle labor cost from you and parts cost? I should send VIH an estimate.

I'll be out of the office Nov 12 thru the 16, please cc cswayne@eaglecopters.com he'll be in the loop.

KL

-----Original Message-----

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, November 11, 2009 8:10 AM
To: 'Bill Beckett'; 'David Duval'
Cc: ssheldon@dartaero.com; mpetsche@dartaero.com; 'Dan Stow'; 'Kelly Labas'
Subject: RE: Repair to VIH Skidtube

David, Dan P. and myself just looked at these skids, and they look like shit, you're probably looking at about 14hrs per tube, and this is just the repair on the crossbolt spacers. Do we need to disassemble and re-paint too?

They look like they have been repainted with a paint brush or roller !
Wouldn't be cheaper to sell them new ones at Eagles cost?

LL

-----Original Message-----

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: November 10, 2009 10:45 AM
To: 'David Duval'
Cc: ssheldon@dartaero.com; 'L Lacelle'; mpetsche@dartaero.com; 'Dan Stow'; 'Kelly Labas'
Subject: Repair to VIH Skidtube

David,

As discussed, please prepare a repair scheme for the VIH skidtube, as well as an estimate of how many hours it will take to repair. Please forward this to Kelly. He will then issue us a PO to do the repairs in accordance to Repair scheme xxx. Once the work is done and Eagle approves it, he will issue us a Serviceable Tag and we can ship the Skidtube back to VIH. There are 2 other VIH Skidtubes on their way to Dart from Eagle for similar repairs.

Thanks,

Bill

PS: Linda - we will need to invoice Eagle our COSTS for doing this work.
Eagle will invoice VIH.



WV 53972

RELEASED
07-06-28

DESIGN #	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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RELEASED
07-06-28

Diagram of a propeller cross-section showing grinding locations and dimensions:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2578-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2578
- $V \frac{1}{4}$

Technical drawing of a circular component with a central hole. The drawing includes the following dimensions and assembly instructions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the central hole.
- SEAL WITH SIKAFLEX-241/-291**: Points to the outer edge of the component.
- AN3-5A BOLT (1)**: Points to the bolt passing through the central hole.
- AN980JD10L WASHER (1)**: Points to the washer under the bolt.
- (2 PLACES)**: Points to the two locations where the bolt and washer are installed.
- D2855 CAP**: Points to the cap being installed on the component.
- 0.008**: Dimension for the central hole.
- 0.40**: Dimension for the outer diameter of the component.

Diagram of a circular spacer assembly. The assembly consists of a central web (D2596 WEB (REF)) and a spacer (D2579 SPACER). The spacer is a circular ring with a central hole. The web is a rectangular plate with a central hole. The assembly is shown with a cross-section view of the spacer and a top view of the web. A list of instructions is provided below the diagram.

5

ALS7-1032-130 (REF)
(TYP 50 PLACES)

D2596 WEB (REF)

D2579 SPACER

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.508$ HOLES ONLY:

1. CHAMFER HOLE $0.050 \times 45^\circ$
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO $\phi 0.437 \times 1.00$ DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2598 WEB

3
7

1.750 1.750

0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

25.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 0 1.5 1.5 1.5

8

P P P P P P P P

REFER TO DETAIL C

D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN560C10L WASHER (1)
(50 PLACES)

DESIGN J DRAWN BY



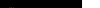


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	CHECKED 	APPROVED 	DRAWING NO. D2580	REV. D SHEET 2 OF 3
	DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:24

Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

RELEASED
07-06-28

GRIND FLUSH (4 PLACES)

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

$\frac{1}{4}$

Diagram illustrating the assembly of a circular component, likely a cap or cover, showing the following components and instructions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Indicated by a line pointing to a hole in the cap.
- SEAL WITH SIKAFLEX-241/-291**: Indicated by a line pointing to the sealant application area.
- AN3-5A BOLT (1)**: Indicated by a line pointing to a bolt.
- AN960J1D1L WASHER (1) (2 PLACES)**: Indicated by a line pointing to a washer.
- D2855 CAP**: Indicated by a line pointing to the cap.
- SEE NOTE ii)**: Indicated by a line pointing to a specific area.
- 0.40**: Dimension indicating the thickness of the component.

5

D2579 SPACER

D2596 WEB (REF)

AL57-1032-130 (REF)
(TYP. 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.50B HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2579 SPACER TO #0.437 X 1.00 DEEP

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible]

(MAKE FROM D2360-1 DRILLING DETAIL)

Technical drawing of a curved pipe section. Dimensions and callouts include:

- Overall length: 51.340
- Distance from left end to first tangent point: 5.985
- Distance between hole and tangent point (left): 1.0
- Distance between hole and tangent point (right): 1.0
- Distance from second tangent point to right end: 32.0 ± 1.0
- Radius of curvature: R = 39.580
- Reference dimension: 5.338 (REF)
- Reference dimension: 3.630 (REF)
- Dimension: 5.915
- Dimension: 20.0
- Dimension: 0.508 (8 PLACES)
- Dimension: 0.640
- Callout 4: Points to the left end and a specific location on the curve.

WELD AS PER DETAIL F

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5

1.5

1.5

H

NO C'BORE NO PLUG

REFER TO DETAIL G

P

P

P

P

P

P

P

NO C'BORE NO PLUG

03566-1

03566-5

03566-13

03564-11

03564-5

03564-9

03564-13

AN3C4A BOLT (1)


AN960C10L WASHER (1)

(50 PLACES)

DESIGN

DRAWN BY

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R4
 CHECKED 
 DATE 07.02.27

APPROVED *[Signature]*

DRAWING 1
02580

REV. C
SHEET 3 OF 3

DRAWING 1
02580

TITLE
205 SKIDTUBE ASSEMBLY

REV. 0
3 OF 3

SCALE
1:24

Work Order Summary

December 10, 2009 9:50:24 AM

Page 1 of 2

Criteria : Work Order ID: 53972 Item ID: D205-634-041RevD Product Family SKIDTUBES
Work Order Start Dates 11/25/09 to 11/25/09 11:59:59 PM Work Order Required Dates 11/30/09 to 11/30/09 11:59:59 PM

All References

Work Order Status Complete

Work Order ID 53972 Required Qty 3.0000 Status Code Complete
Item ID D205-634-041RevD Accepted Qty 0.0000 Scrap Qty 0.0000
Item Name Replacement Skidtube
Current Acct Value \$1,065.417 Sales Order ID
Start Date 11/25/09 Required Date 11/30/09 Completed Date 12/10/09 9:50:06 AM

Standard	** Actual **	** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each
Material	\$0.000	\$0.000	\$168.954	\$168.954 100.00%
Labor	\$770.148	\$0.000	\$345.711	\$345.711 100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
Variable Burden	\$0.000	\$0.000	-\$0.035	-\$0.035 100.00%
Fixed Burden	\$1,455.626	\$0.000	\$686.388	\$686.388 100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000 0.00%
** Total **	\$2,225.774	\$0.000	\$1,201.017	\$1,201.017

Work Center HandFinish

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
DUBO01		12/04/09										
200			0.00	0.00	2.34	2.34	1.00	\$0.000	\$36.417	\$57.260	\$0.000	\$93.67
ROQU01		12/02/09										
170			0.00	0.00	0.84	0.84	1.00	\$0.000	\$13.006	\$20.450	\$0.000	\$33.45
		12/03/09										
170			0.00	0.00	2.81	1.40	2.00	\$0.000	\$21.824	\$34.314	\$0.000	\$56.13
Total:			0.00	0.00	5.99	4.58	4.00	\$0.000	\$71.246	\$112.024	\$0.000	\$183.27

Work Center Skidtubes

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
ELL101		11/26/09										
140			0.00	0.00	0.71	0.71	1.00	\$0.000	\$13.409	\$25.342	\$0.000	\$38.75
140			0.00	0.00	4.84	4.84	1.00	\$0.000	\$91.933	\$173.747	\$0.000	\$265.68
		12/01/09										

December 10, 2009 9:50:24 AM

Work Order Summary

Page 1 of 2

140		0.00	0.00	3.08	3.08	1.00	\$0.000	\$58.427	\$110.423	\$0.000	\$168.84
140		0.00	0.00	3.68	3.68	1.00	\$0.000	\$69.868	\$132.047	\$0.000	\$201.91
140		0.00	0.00	0.75	0.75	1.00	\$0.000	\$14.243	\$26.918	\$0.000	\$41.16
12/02/09											
140		0.00	0.00	1.08	1.08	1.00	\$0.000	\$20.441	\$38.632	\$0.000	\$59.07
140		0.00	0.00	3.36	3.36	1.00	\$0.000	\$63.791	\$120.562	\$0.000	\$184.35
MAHE01											
11/25/09											
140		0.00	0.00	2.82	2.82	1.00	\$0.000	\$53.584	\$101.271	\$0.000	\$154.85
MYRE01											
12/01/09											
140		0.00	0.00	1.39	1.39	1.00	\$0.000	\$26.455	\$49.998	\$0.000	\$76.45
PAQU03											
11/25/09											
140		0.00	0.00	2.96	2.96	1.00	\$0.000	\$56.115	\$106.055	\$0.000	\$162.17
140		0.00	0.00	3.80	3.80	1.00	\$0.000	\$72.173	\$136.404	\$0.000	\$208.57
11/30/09											
140		0.00	0.00	2.20	2.20	1.00	\$0.000	\$41.767	\$78.937	\$0.000	\$120.70
140		0.00	0.00	0.94	0.94	1.00	\$0.000	\$17.856	\$33.747	\$0.000	\$51.60
12/01/09											
140		0.00	0.00	0.53	0.53	1.00	\$0.000	\$9.996	\$18.893	\$0.000	\$28.88
12/02/09											
140		0.00	0.00	3.10	3.10	1.00	\$0.000	\$58.774	\$111.080	\$0.000	\$169.85
Total:		0.00	0.00	35.22	35.22	15.00	\$0.000	\$668.831	\$1,264.053	\$0.000	\$1,932.88

Work Center SprayPaint

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
murd02												
12/03/09												
175			0.00	0.00	1.86	1.86	1.00	\$0.000	\$30.071	\$79.549	\$0.000	\$109.62
Total:			0.00	0.00	1.86	1.86	1.00	\$0.000	\$30.071	\$79.549	\$0.000	\$109.62

L Lacelle

From: Angela Albert [aalbert@eaglecopters.com]
Sent: December 10, 2009 1:20 PM
To: 'L Lacelle'
Cc: 'Suzanne Bedford'; 'Kelly Labas'
Subject: RE: Eagle rework skidtubes

Hi Sue,

Can you send me any paperwork you have on these items? If you could fax over as I will not be in tomorrow and on holidays for the new 2 weeks that would be great.

Thanks Sue,
Angie

ANGELA ALBERT
INTERMEDIATE ACCOUNTANT
Eagle Copters Maintenance Ltd/Dart Aerospace
Phone: (403) 250-7370 Ext 107
Fax line: (403) 291-1509
Email: aalbert@eaglecopters.com
Website: www.eaglecopters.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Thursday, December 10, 2009 7:59 AM
To: aalbert@eaglecopters.com
Cc: 'Suzanne Bedford'; 'Kelly Labas'
Subject: Eagle rework skidtubes

The total cost for the 3 skidtubes for VIH is 2225.77 (741.92 ea). Please bill eagle accordingly and let Sue know if there is anything for her to do with the order entry.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

Receiving Report

Date: 9/14/9

Batch No: M113137

Supplier: REGVE

Dart P/O: NR

Packing Slip: Yes ☒ No ☒
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☒
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☐ N/A ☒
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	2 BOP For DAE Show					

Initials of receiver (if shipment OK) Level 12 LR

Production/Admin: _____
 Date _____
 Received/Costing _____
 Initial _____

Location _____

H:\FORMS\Purchasing\approved purch\RECREPORT Rev.D

* End of Report *

REFERENCE ONLY

>> denotes that the Packing Slip line item has already been printed.

**VIH HELICOPTERS LTD.**1962 CANSO ROAD, NORTH SAANICH, BC V8L 5V5
PH: (250) 656-3987W.O. No. 24-28335Nomenclature SKID TUBE Date 12 OCT 2009Part Number D205-634-011 Serial # NSNRemoved from C-FBV1 A/C hrs. 27335.2TSN V/K TSO N/K RINS/Cycles N/KReason for removal SPACERS FOR GHW LOGSName (Print) WORN / MISSING PARTICLE Signature [Signature] GA No. 77

UNSERVICEABLE

Action to be taken _____

Remarks _____



VIH HELICOPTERS LTD.

1962 CANSO ROAD, NORTH SAANICH, BC V8L 5V5
PH: (250) 656-3987

W.O. No. 29-30194

Nomenclature SKID-TUBE Date OCT 21/07

Part Number D205-634-011 Serial # UNK

Removed from C-FU1K A/C hrs. 8720.0

TSN TSO RINS/
Cycles

Reason for removal CRACKS/HOLES FOUND in

FORWARD + AFT SADDLE BOLT HOLES

Name (Print) MIKE PELUSHINSKY Signature [Signature] CA No.

UNSERVICEABLE

UNSERVICEABLE

Action to be taken

REPLACE SPEAKERS AS REQ'D

Remarks

Eagle Copters Maintenance Ltd

823 McTavish Rd, NE
Calgary, Alberta T2E 7G9
Canada

PACKING SLIP

Date Shipped: November 03, 2009

Telephone: (403) 250-7370

Fax: (403) 250-7110

Shipment number: SH#09-003910

Manifest number:

Ship To: Dart Aerospace Ltd

1270 Aberdeen Street
Hawksbury, On K6A 1K7
Canada

ATTN: DAN STOW

Ship Via: DAYROSS

Carrier Terms:

Waybill: Unknown

Shipping Instructions:

Customer P.O. Number: 258852

Phone: 613-632-5200

Item	Part Number	Part Description	Current Location	Qty	UOM	Serial Number	Lot Number
1	D205-634-011	Skidtube (Fits LH or RH)	Shipping Area	1	Each	NA	

Work Order Number: 46229.1.1 #1

Service description: Repair

Eagle PO Number PO-09-002632.2

24308

Work Instructions:

Comments

For repair and return to Eagle.

* End of Report *

REFERENCE ONLY

>> denotes that the Packing Slip line item has already been printed.

David Duval

From: Kelly Labas [klabas@eaglecopters.com]
Sent: November 11, 2009 10:21 AM
To: 'L Lacelle'; 'Bill Beckett'; 'David Duval'
Cc: ssheldon@dartaero.com; mpetsche@dartaero.com; 'Dan Stow'; 'Craig Swayne'
Subject: RE: Repair to VIH Skidtube

Yikes! How much to paint if we do not disassemble just slam them thru the both to make them look somewhat respectable, they are used tubes.

What's Eagle labor cost from you and parts cost? I should send VIH an estimate.

I'll be out of the office Nov 12 thru the 16, please cc cswayne@eaglecopters.com he'll be in the loop.

KL

-----Original Message-----

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, November 11, 2009 8:10 AM
To: 'Bill Beckett'; 'David Duval'
Cc: ssheldon@dartaero.com; mpetsche@dartaero.com; 'Dan Stow'; 'Kelly Labas'
Subject: RE: Repair to VIH Skidtube

David, Dan P. and myself just looked at these skids, and they look like shit, you're probably looking at about 14hrs per tube, and this is just the repair on the crossbolt spacers. Do we need to disassemble and re-paint too?

They look like they have been repainted with a paint brush or roller !
Wouldn't be cheaper to sell them new ones at Eagles cost?

LL

-----Original Message-----

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: November 10, 2009 10:45 AM
To: 'David Duval'
Cc: ssheldon@dartaero.com; 'L Lacelle'; mpetsche@dartaero.com; 'Dan Stow'; 'Kelly Labas'
Subject: Repair to VIH Skidtube

David,

As discussed, please prepare a repair scheme for the VIH skidtube, as well as an estimate of how many hours it will take to repair. Please forward this to Kelly. He will then issue us a PO to do the repairs in accordance to Repair scheme xxx. Once the work is done and Eagle approves it, he will issue us a Serviceable Tag and we can ship the Skidtube back to VIH. There are 2 other VIH Skidtubes on their way to Dart from Eagle for similar repairs.

Thanks,

Bill

PS: Linda - we will need to invoice Eagle our COSTS for doing this work.
Eagle will invoice VIH.

Receiving Report

Date:

9/10/21

Batch No:

M/12976

Supplier:

VIN

Dart P/O:

Packing Slip:

Yes

☒

No

☐

Release Note Attached:

Yes

☐

No

☐

N/A

☒

Invoice:

Yes

☐

No

☒

Waybill Attached:

Yes

☒

No

☐

N/A

☐

Receipt:

Cash

☐

Cr

☒

Shipment Complete:

Yes

☒

No

☐

N/A

☐

QC6 Inspection

☒

☐

N/A

☐

Work Order

☐

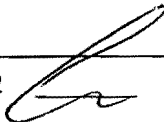
N/A

☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12



Production/Admin:

Date

Location

Received/Costing

Initial

[illegible]

VIH Helicopters Ltd.

1962 Canso Road
North Saanich, B.C.
Canada V8L 5V5

(hereafter "Purchaser") **REPAIR P/O**

DATE 10/05/09
P/O NUMBER 258796
PAGE 1 OF 2

VENDOR:

DART HELICOPTER SERVICES LLC
PO BOX 37

HAWKESBURY, ON K6A2R4

ATTN:
PH:8005564166 FX:6136324443

SHIP TO:

VIH HELICOPTERS LTD.
BOX 368, 4275 HANGAR RD.
PRINCE GEORGE, BC V2L 4S2

BUYER: KEITH LANDRY
PHONE: (250) 963-9884
FAX: (250) 963-9832
TERMS:
VENDOR CODE: US-DAR
SHIP VIA:

INVOICE TO:

VIH HELICOPTERS LTD.
1962 CANSO ROAD
NORTH SAANICH, BC V8L 5V5

ITEM	DESCRIPTION	DATE	QTY	U/M	PRICE	TOTAL
------	-------------	------	-----	-----	-------	-------

001	D205-634-011 SKID TUBE REQUISITION#:	11/01/09 T/C: 29 30194	1	EA	GL:106501	
-----	--	---------------------------	---	----	-----------	--

Repair order number: 011662 S/N: B37497

REPAIR ORDER NUMBER: 011662
A/C TYPE: A/C REG.:

-----REQUESTED REPORTS-----
TEARDOWN REPORT.....: X APPROVED CERTIFICATE....: X
LOG CARD.....: FINDING/TEST REPORT.....: X

-----WORK TO BE DONE-----
OVERHAUL.....: INSPECTION CHECK.....:
REPAIR.....: X MODIFICATION.....:
BENCH CHECK.....:

CRACKS FOUND IN BOLTHOLES FOR SADDLE MOUNT

PURCHASE ORDER TOTAL: USD

***** PURCHASE ORDER TERMS AND CONDITIONS *****

Certification must be provided with ALL Aeronautical Products (Components, Parts and Materials) in accordance with Transport Canada and/or FAA regulations. TC Airworthiness Notice B073 and FAA Advisory Circular No. 20-62. We reserve the right to reject any Aeronautical Products not conforming to these regulations.

THE TERMS AND CONDITIONS EMBODIED ON THE FRONT OF THIS ORDER PLUS THOSE ATTACHED SHALL CONSTITUTE THE SOLE AND FUTURE CONTRACT OF PURCHASE OF THE ARTICLES DESCRIBED HEREON. THE ORDER SHALL NOT BE BINDING ON THE PURCHASER UNLESS SIGNED BY PURCHASER'S PURCHASING AGENT AND/OR BUYER.

SELLER MUST QUOTE A FIRM PRICE ON ANY UNPRICED ITEMS ON THIS BEFORE PROCEEDING.

SIGNATURE

STIPULATIONS:

- PURCHASER RESERVES THE RIGHT TO CANCEL ALL OR ANY PART OF THIS ORDER IF DELIVERY NOT EFFECTED IN ACCORDANCE WITH INSTRUCTIONS.
- ALL GOODS SUBJECT TO INSPECTION AND REJECTION AT PURCHASER'S FACILITY WITHIN 90 DAYS AFTER RECEIPT.
- THIS ORDER MUST NOT BE CHANGED IN QUANTITY OR FILLED AT HIGHER PRICES WITHOUT AUTHORITY OF PURCHASER IN WRITING.

- ENCLOSE PACKING SLIP IN DUPLICATE REFERRING TO PURCHASER'S PURCHASE ORDER NUMBER.
- PARTIAL SHIPMENTS MUST HAVE PRIOR APPROVAL IN WRITING.
- RENDER INVOICE IN DUPLICATE; SEPARATE INVOICE FOR EACH SHIPMENT.
- FOREIGN SUPPLIERS MUST COMPLY WITH CUSTOMS REGULATIONS.

Epic Express A TransForce Company

CONSIGNEE
DESTINATAIRE 430-0450343 430 30
DART
PO BOX 37
HAWKESBURY, ON K6A 1K7

SHIPPER
EXPÉDITEUR 011-0546416 011
VIH HELICOPTERS LTD.
4275 HANGER ROAD
PRINCE GEORGE, BC V2L 4S2

BEYOND/PLUS LOIN

TRAILER/ REMORQUE

DATE

PRO NUMBER/NUMERO PRO

B9-247

10/09/09

455-548892

BILL TO/FACTURE A

CREDIT ACCOUNT

ADVANCE/AVANCE

PIECES COLIS	DESCRIPTION OF ARTICLES AND MARKS DESIGNATION DES ARTICLES	WEIGHT POIDS	RATE TARIF	CHARGES PRAIS	TERMS CONDITIONS
1	LONG CARDBOARD BOX LTL FUEL SURCHARGE 16.04% GOODS AND SERVICES TAX 5% PRO# 170885	70			PPD
1	TOTAL 455-548892	70			
3RD PARTY VIH HELICOPTERS LTD. SIDNEY, BC V8L 4R1 145125324					

G.S.T.

Short or damage notation on delivery receipt is not notice of claim. Notice of claim must conform to conditions of the standard bill of lading, item 12.
Indication d'articles endommagés sur le bordereau de livraison ne peut servir à une demande de remboursement. Celle-ci doit être conforme à l'article 12 du connaissement.

Received above described in good order except as noted visible damage or shortage must be noted on delivery. / Les colis mentionnés ci-dessus ont été reçus en bonne et due forme excepté si mentionné. Le dommage visible et les articles en moins doivent être mentionnés sur le bordereau de livraison.

DATE

TIME/TEMPS

DRIVER

PIECES/COLIS

RECEIVED IN GOOD ORDER BY/REÇU EN BON ÉTAT PAR

X

THIS IS NOT AN INVOICE / CECI N'EST PAS UNE FACTURE
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